

Date: Thursday, 9/14/2006 7:27:47 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 28550	
Estimate Number : 10260	
P.O. Number : <i>N/A</i>	Part Number : D23623
This Issue : 9/14/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 27765	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/30/2006 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: G 00.05 18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
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1	D2265	Step Support	<i>B25401</i>	<i>J.G</i>	<i>06/09/29</i>	<i>6</i>
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2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

<i>J.G</i>	<i>06/09/29</i>	<i>6</i>
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3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

<i>SA</i>	<i>06.09.29</i>	<i>(6)</i>
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4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

<i>SA</i>	<i>06.09.29</i>	<i>6</i>
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

<i>J.G</i>	<i>06/09/29</i>	<i>6</i>
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

<i>G.M</i>	<i>06/10/11</i>	<i>(6)</i>
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:27:47 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 28550

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF. 06/10/11

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

627768

MF. 06/10/11

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

627769

MF. 06/10/11

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch ~~M11174~~ M100374

MF. 06/10/12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/10/16

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57173

DB 06/10/17

(6)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/18

Job Completion



u 06/10/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	28550
Description: Step Support Bracket		Part Number:	D2362-3
Inspection Dwg: D2362	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	0.258	✓			
3.074	+/-0.010	3.070	✓			
0.34	+/-0.030	0.349	✓			
0.77	+/-0.030	0.785	✓			
1.500	+/-0.010	1.500	✓			
1.000	+/-0.010	1.005	✓			
0.80	+/-0.030	0.815	✓			
1.200	+/-0.010	1.210	✓			
1.28	+/-0.030	1.235	✓			
1.000	+/-0.010	1.008	✓			
0.75	+/-0.030	0.760	✓			
1.88	+/-0.030	1.899	✓			

Measured by: J.G	Audited by: SD	Prototype Approval:	N/A
Date: 06/09/29	Date: 06.09.29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	JF

DART



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	#	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

07.03.15 CP

DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE
OK 07/04/04

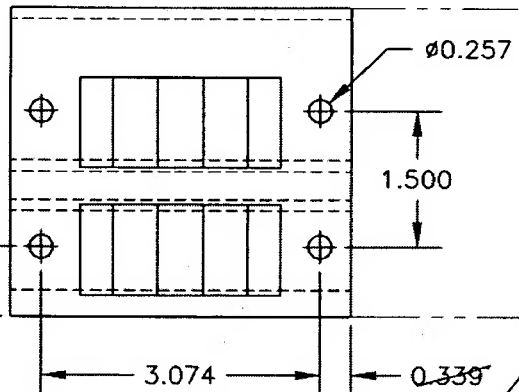
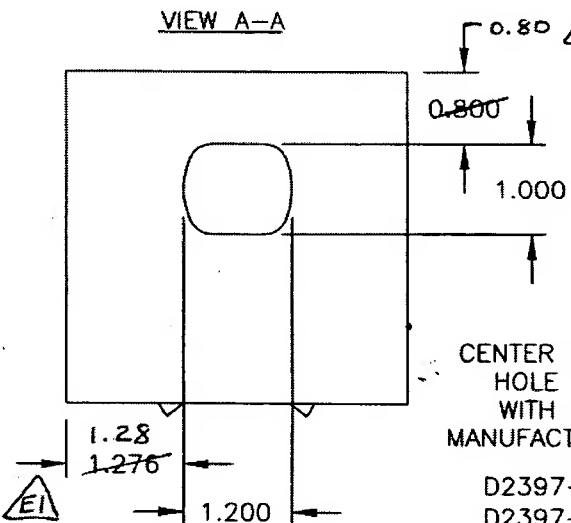
0.257 X 0.75 SLOT

REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

VIEW A-A



D2362-3

0.77, 0.767, feature EI

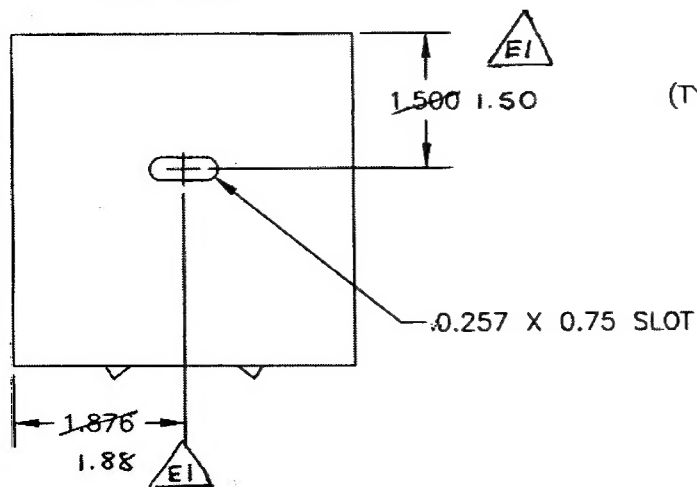
WORK ORDER
NO. 28550
NOTES:
MAKE FROM 02265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING



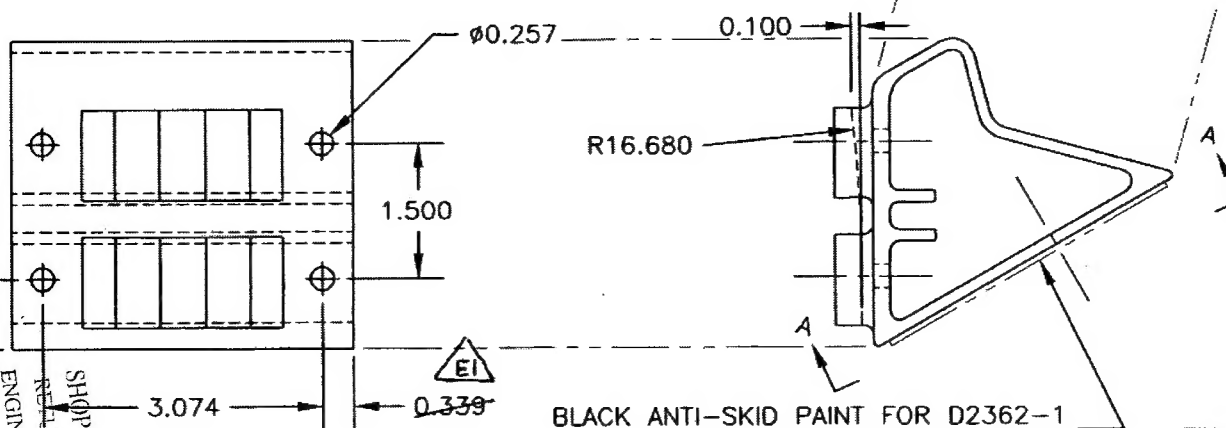
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2362	SHEET 2 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

RELEASED
98.12.14
UNDER REVIEW
31.03.05 CP

DESIGN OK, BUT CHECK BY
D23 BEFOR MANUFACTURE
OK 08.10.05

0.77
NOTE: 1. MAKE FROM D2265
2. D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3. D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
4. FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
5. BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 28550



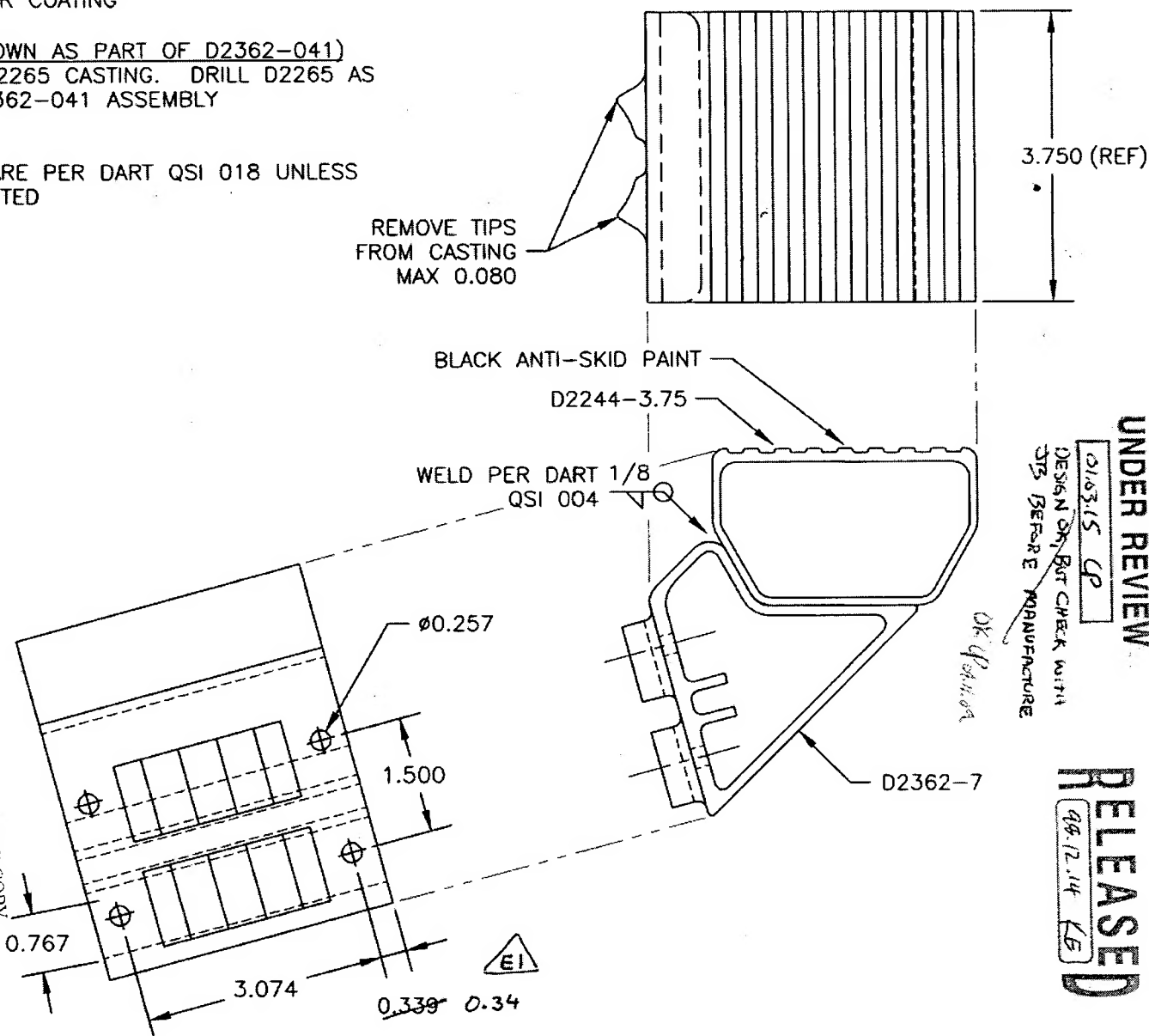
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	REV. E
DATE 98.12.04	DRAWING NO. D2362	SHEET 3 OF 3
	TITLE STEP SUPPORT BRACKET	SCALE 1:2

UNDER REVIEW

RELEASED
98.12.14 KE

016315 CP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

OK 98.12.04



D2362-041 (SHOWN)
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

